

Date: Wednesday, 3/14/2007 3:27:37 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 STEP LUG
Job Number	: 31209		
Estimate Number	: 11843		
P.O. Number	: <i>N/A</i>	Part Number	: D23381
This Issue	: 3/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2338 REV B <i>U/R</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/14/2007 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 3/23/2007
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est. B00.03.24 Separated -1 from -2 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.3827 f(s)/Unit Total: 2.2964 f(s)

6061-T6 Bar .50" x 6.0"

Material: 6061-T6 0.5 x 6.0"

Batch: *7103438*

1 blank makes one D2338-1 &amp; one D2338-2

*ml 07/03/19*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks 8.75" long

*ml 07/03/19*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2338

Tumble &amp; Deburr

*SA/ml 07/03/19*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 07.03.20*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.F. 07/03/20**(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/14/2007 3:27:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 STEP LUG

Job Number: 31209

Part Number: D23381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/13/22

(6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



U 07-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

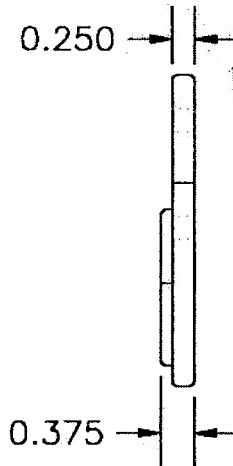
**DART**



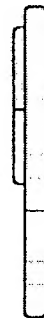
DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>B.S.</i>	APPROVED	<i>B.S.</i>	DRAWING NO. D2338
DATE	95.01.25	TITLE	ENDPLATE	REV. B SHEET 1 OF 1
				SCALE 1:2
B	96.03.29	RE-DESIGN AND ADD D2338-2		

**RELEASED**  
97/04/22

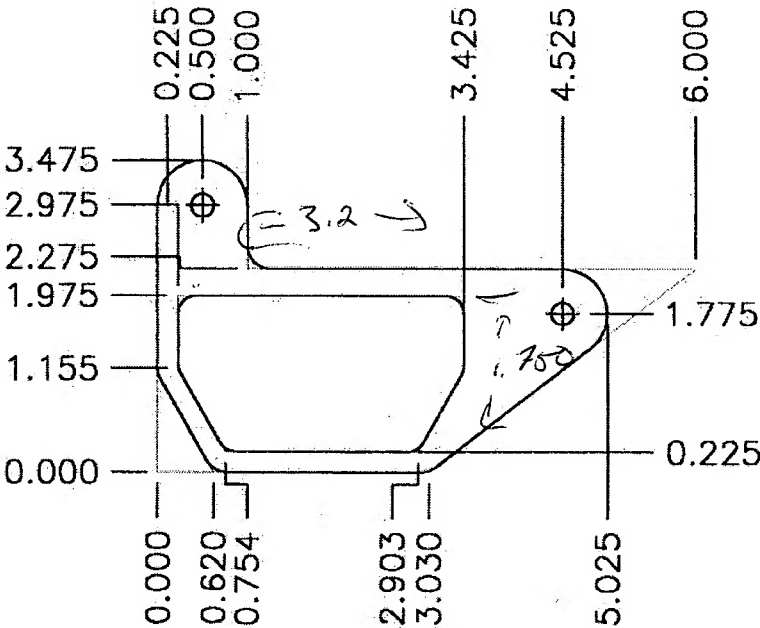
UNDER REVIEW



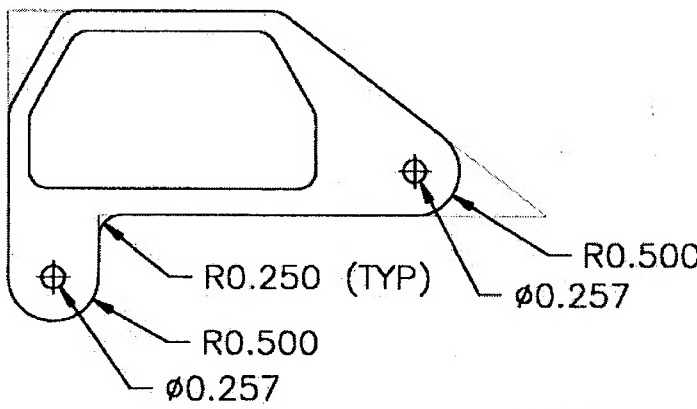
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31209
<b>Description:</b> D2338 Endplate		<b>Part Number:</b> D2338-1
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.975	±.010	1.980	/			
B .225	±.010	.225	/			
C 2.275	±.010	2.277	/			
D 3.475	±.010	3.478	/			
E .225	±.010	.226	/			
F .500	±.010	.500	/			
G 1.000	±.010	1.001	/			
H 3.425	±.010	3.421	/			
I 4.525	±.010	4.526	/			
J 5.025	±.010	5.029	/			
K						
L .250	±.010	.250	/			
M .375	±.010	.369	/			
N						
O Ø.257		Ø.257	/			
P R.500		R.500	/			
Q R.250		R.250	/			
R						
S						
T						
U						
V						
W						
X						
Y						

<b>Measured by:</b> SA	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07.03.20	<b>Date:</b> 07/03/20	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	